

359

REPLANT S.F.

DART
AEROSPACE

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1270 Aberdeen St
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Canada
Tel (613) 632-5200

RBT400315
Job Sheet 173356

Part No: RBT400315 **Job Qty:** 1 ea
Part Name: Main Transmission Backlash Tool

Part Weight: 0 lbs **Status:** Scheduled **Priority:** High
Job Created: 2/28/18 **Job Tracking No:**
Due Date: 4/30/18 **Created By:** Marie Lajeunesse
Type: SOLD **Description:**
Note: DWG RBT400315 Rev 0 IPP Rev 0 18.02.26 New issue DP Verify DD
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	Sign-off
90	Start up Operation	1 Ea	4/28/18	4/28/18	0.00	0.00	Start Up Small Fab-2		MLC
110	Small Fab	1 pcs	4/30/18	4/30/18	0.00	0.25	Small Fab-3		MLC DAS
120	QC	1 pcs	4/30/18	4/30/18	0.00	0.00	QC5		38
130	Packaging	1 pcs	4/30/18	4/30/18	0.00	0.00	Packaging3-1		9-88
140	QC21-SA	1 Ea	4/30/18	4/30/18	0.00	0.00	QC21		DAS 21 9-88

Part Op 110 - 1-Press in dowel pin as per DWG. view A-A. 2-Assemble as per DWG.
Descriptions:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91083A032	Flat Washer	2 Ea (2 ea)	90-Start up Operation	5048592
94846A520	Hex Nut	1 Ea (1 ea)	90-Start up Operation	5048593
98381A216	Dowel Pin	1 Ea (1 ea)	90-Start up Operation	5048591
RBT400315-3	Arm	1 Ea (1 ea)	90-Start up Operation	
RBT400315-5	Coilset	1 Ea (1 ea)	90-Start up Operation	
RBT400315-7	Bolt	1 Ea (1 ea)	90-Start up Operation	5069188
RBT400315-1				5069856

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	91083A032	2	105	0
	94846A520	1	50	0
	98381A216	1	100	0
	RBT400315-3	1	4	0
	RBT400315-5	1	0	0
	RBT400315-7	1	0	0

Part Specifications

Specifications could not be found.

Plex 4/25/18 2:36 PM dart.logan.david



Container No: S070533



Part: RBT400315

Job No: 173356

Serial No/Batch: S070533

Revision: 0

Inspector:

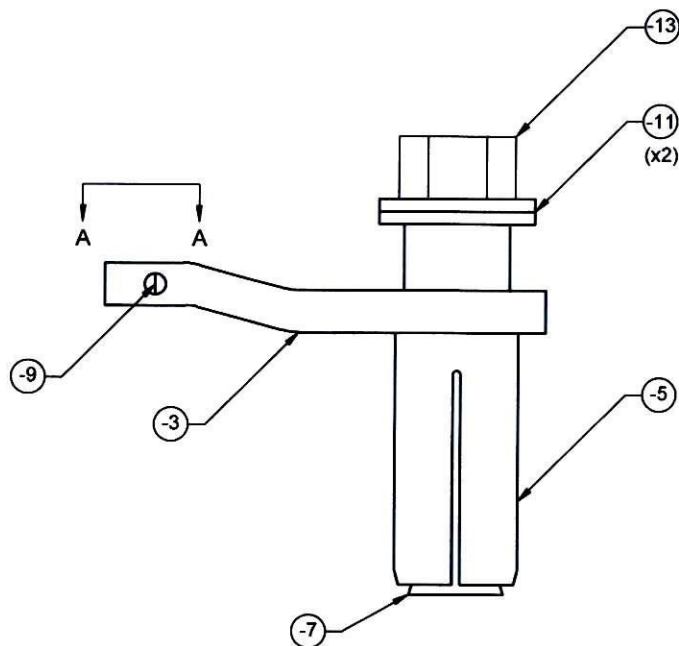
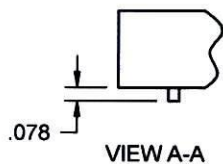
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Date: 05/11/18

05/11/18
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173356

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
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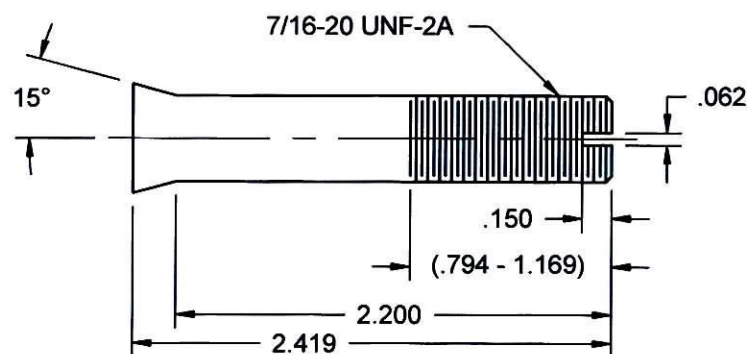
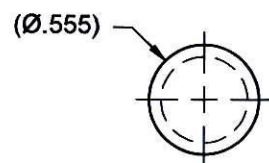


ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
	1		-1	1	WELDMENT			2
	1		-3		ARM	A36 PLATE	1/4 x 1-1/8 x 2-7/8	3
	1		-5		COLLET	4140 Q&T	Ø3/4 x 2-1/4	4
			-7	1	BOLT	STEEL	7/16-20 UNF -2A MCMaster-CARR #91247A326 (NEEDS MOD.)	5
		B/O	-9	1	DOWEL PIN	STEEL	Ø1/8 x 5/16 MCMaster-CARR #98381A216	1
		B/O	-11	2	FLAT WASHER	STEEL	15/32 I.D. x 59/64 O.D. x .05 MCMaster-CARR #91083A032	1
		B/O	-13	1	HEX NUT	STEEL	7/16-20 UNF -2B MCMaster-CARR #94846A520	1
ASSY	-1							

RED BARN MACHINE	
TITLE MAIN XSMN BACKLASH TOOL	
DWG NO. RBT400315	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 ANGLES ± 5° METRIC REF. .XXmm ± .1mm FRACTIONS ± 1/32 ANGLES ± 5° UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: CLOUGH APPROVED: <i>D. Weil</i> TREAT: FINISH: SPEC: USED ON MODEL: BELL 204, 205, 212	
SCALE NTS	DATE 1-11-11
SHEET 1 of 5	

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REVISIONS			
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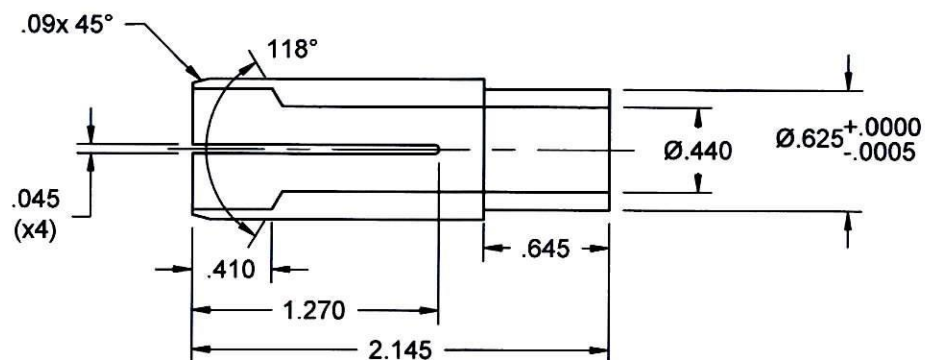
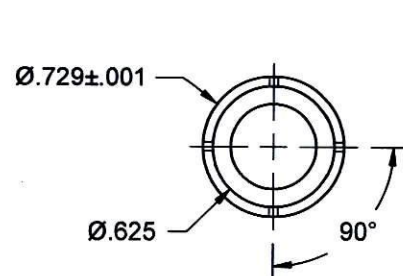


(-7)
BOLT

RED BARN MACHINE	
TITLE MAIN XSMN BACKLASH TOOL	
DWG NO. RBT400315-7	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS METRIC REF. .XXX ± .005 .XXmm ± .1mm .XX ± .01 FRACTIONS ± 1/32 .X ± .1 ANGLES ± 5°	DRAWN BY: CLOUGH APPROVED: <i>D. Wed</i> HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL BELL 204, 205, 212
SCALE NTS	DATE 1-11-11
SHEET 5 of 5	

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
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(-5)
COLLET

RED BARN MACHINE	
TITLE MAIN XSMN BACKLASH TOOL	
DWG NO. RBT400315-5	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 METRIC REF. .XXmm ± .1mm FRACTIONS ± 1/32 ANGLES ± 5° UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: CLOUGH APPROVED: <i>D. Wed</i> HEAT TREAT: SEE WELDMENT FINISH: SEE WELDMENT SPEC: USED ON MODEL BELL 204, 205, 212	
SCALE NTS	DATE 1-11-11
SHEET 4 of 5	